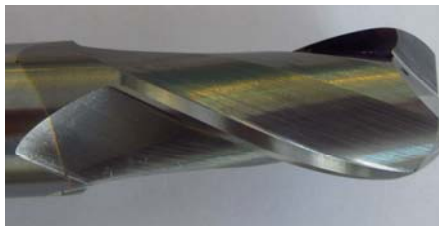
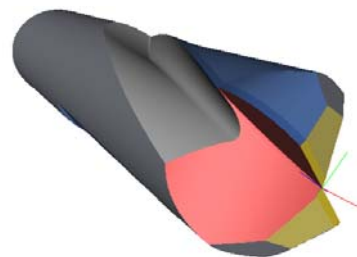


Flatface Radius Endmill Ø25/15 Z2 R10

A01-110

The flatface radius endmill type A01-110 in Quinto5 allows to produce and resharp radius endmills with tangential begining of the radius at OD and given enddiameter .
Optionally the radius can be defined tangential to the end.
Straight or radial gashings are possible and adjustable along the radius. Wheels and grinding processes of flute, gashing, end and OD are similar to common standard tools.
The below cycle time is calculated for production.



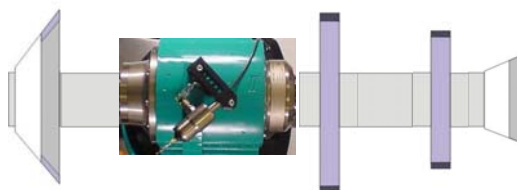
1. Cycletime for Production

| Workpiece: Ø25 mm, Z 2, L 45 mm Material CARBIDE | | | | | | | | | | | |
|--|-----------|---------|---------|-------|-------|-------|-------|-------|----------|----------|----------|
| Operations | Probe | Flute 1 | Gashing | O.D.3 | O.D.2 | O.D.1 | End 2 | End 1 | Radius 2 | Radius 1 | backclr. |
| Feed [mm/Min] | 2000 | 60 | 80 | 100 | 170 | 220 | 80 | 100 | 120 | 120 | 100 |
| Power [kW] | | 3 | 2 | 1 | 1 | 2 | 1 | 1 | 4 | 3 | 2 |
| Cutting speed [m/s] | | 20 | 22 | 22 | 22 | 22 | 22 | 22 | 22 | 22 | 22 |
| Used wheels | | 1 | 2 | 2 | 3 | 3 | 4 | 4 | 4 | 4 | 4 |
| Grinding time [s] | 20 | 123 | 57 | 286 | 184 | 147 | 42 | 37 | 73 | 73 | 58 |
| Total cycle time | 18 Min 20 | | | | | | | | | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|---------------|
| 1 | 1A1 Ø125 D64 |
| 2 | 12V9 Ø125 D64 |
| 3 | 1A1 Ø100 D64 |
| 4 | 11V9 Ø75 D64 |



2

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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG Coolant: Synthetic Oil, pressure 6 bar
Control: Fanuc 310i Software: Quinto 5
Accessories:

Responsible engineer: OP. 7.2.12

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